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3. (Amended) [Process] The process [according to one of the preceding claims, characterized in that] of claim 1 wherein the first material is injected into the injection mold to such an extent that after injection of the other material, the first material extends to a shoulder in the hollow between the partial area and the remaining area.

4. (Amended) [Process] The process [according to one of the preceding claims, characterized in that] of claim 1 wherein after injection of the first material, a slide gate is moved to clear at least a part of the remaining area.

5. (Amended) [Process] The process of [according to] claim 4[, characterized in that] wherein the slide gate clears a channel leading to a partial area of the hollow in the injection mold.

6. (Amended) [Process] The process of [according to] claim 4[, characterized in that] wherein the slide gate directly clears a partial area of the hollow in the injection mold.

7. (Amended) [Process] The process [according to one of the preceding claims, characterized in that] of claim 1 wherein during the injection molding [operation] steps a gas space is formed in the injection mold.

8. (Amended) [Process] The process [according to one of the preceding claims, characterized in that] of claim 1 wherein one of the first and second plasticized [material] materials is a relatively soft or rubber-like material, and [at least one] the other one of the first and second plasticized [material] materials is a relatively hard material.

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9. (Amended) [Process] The process [according to one of the preceding claims, characterized in that] of claim 1 wherein the first and second plasticized materials exhibit at least two different colors or are transparent.

10. (Amended) [Process] The process [according to one of the preceding claims, characterized in that] of claim 1 wherein at least one of the first and second plasticized [material] materials contains gas pockets.

11. (Amended) [Process] The process [according to one of the preceding claims, characterized in that] of claim 1 wherein at least one of the first and second plasticized [material] materials contains pockets of another component.

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12. (Amended) [Injection] An injection mold, [characterized in that it comprises]
comprising a body member having a wall surface bounding a hollow for so
receiving a first plasticized material as to wet only a partial area of the wall
surface of the hollow, and subsequently so receiving a second plasticized
material as to wet at least a part of the remaining area of the wall surface of
the hollow; and a sensor arranged at [the] a transition between the partial
area and the remaining area of the wall surface of the hollow [in the injection
mold] of the body member.

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13. (Amended) [Injection] The injection mold[, in particular according to] of claim
12[, characterized in that it comprises] wherein the body member is formed
interiorly with a shoulder arranged at the transition between the partial area
and the remaining area of the wall surface of the hollow [in the injection
mold].

14. (Amended) [Injection] The injection mold[, in particular according to] of
claim 12 [or 13, characterized in that it comprises], and further comprising a
hot runner with a by-pass device which enables plasticized material,
streaming to the hollow, to flow into an overflow.

15. (Amended) [Injection] An injection molding device with a plasticizer unit and
an injection unit, [characterized in that it comprises] comprising at least two
secondary extruders which are arranged between screw tip and nozzle tip.

16. (Amended) [Injection] An injection molding device having at least one injection unit which includes an injection piston (201) for injecting melt from a melt compartment, and at least two extruders (203, 204) connected to this melt compartment.

17. (Amended) [Injection] An injection molding device having a main extruder (237, 257) which includes a melt compartment from which a nozzle extends via a hot runner (241), and a secondary extruder (236, 258), [characterized in that] wherein the melt compartment is connected via a control [device] unit (230, 240) to a second channel which is connected with the secondary extruder (236, 258) and leads to the melt compartment, with the control device being coupled with the movement of the secondary extruder.

18. (Amended) [Injection] The injection molding device [according to] of claim 17, [characterized in that] wherein the control unit (230, 240) is rigidly connected with the secondary extruder (236).

19. (Amended) [Injection] The injection molding device [according to] of claim 17 [or 18], [characterized in that] wherein the control unit (230) includes an adjustment nozzle which bears upon a surface, preferably of a secondary extruder, and is secured to a flange.

20. (Amended) [Injection] The injection molding device molding device [according to one of the claims] of claim 17 [to 19], [characterized in that] wherein the hot runner (241) includes a pressure-dependent valve (245).

21. (Amended) [Injection] The injection molding device molding device [according to one of the claims] of claim 17 [to 20], [characterized in that] wherein the control unit (230, 240) includes two partial channels (234, 235; 241, 242, 243) which, depending on the position of the control unit, open or close the hot runner or a feed channel from the secondary extruder.

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22. (Amended) [Injection] The injection molding device [according to] of claim 21, [characterized in that] wherein the control unit (230) includes a partial runner block (231) which accommodates the partial channels (234, 235) and is guided in a block guide (233).

23. (Amended) [Injection] An injection molding device comprising a main extruder (257) movable along a path between an injection position and an idle position, and a secondary extruder (258), [characterized by] and a control unit (250) which is arranged between the injection position and the idle position and includes a channel (253) with an inlet (251) and an outlet (252) and which is swingable between a charging position and release position, wherein the inlet (251) points to the main extruder (257) in the charging position, and the outlet (252) points to the main extruder (257), and wherein the path is cleared for the main extruder (257) in the release position.

24. (Amended) [Injection] The injection molding device [according to] of claim 23, [characterized in that] wherein the inlet (251) and the outlet (252) define an acute angle relative to one another.

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25. (Amended) [Injection] An injection molding device comprising a main extruder movable along a path between an injection position and an idle position, and having a nozzle (301) for projecting in its injection position through a nozzle plate (302) and at least a portion of an adapter plate (303) through an injection opening (304), and a secondary extruder which is shiftable between a charging position and a release position, wherein in the release position the path of the main extruder is cleared and in the charging position an outlet (307) of the secondary extruder points to the nozzle (301) of the main extruder, characterized in that the outlet (307) is arranged in an opening (305) of the adapter plate (303) which terminates in the injection opening (304).

26. (Amended) [Injection] The injection molding device [according to] of claim 25, [characterized in that] wherein the secondary extruder is supported on its side of the outlet, at least in its charging position, by a force applied by the main extruder.

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27. (Amended) [Method] A method of charging a main extruder of an injection molding device with a melt from a secondary extruder, comprising filling the melt into the main extruder via a feed channel in a hot runner which, on the one hand, is connected with the main extruder and, on the other hand, leads to a mold, and so controlling the injection process that in the hot runner between mold and the location at which the feed channel terminates in the hot runner, a sprue of a solidified or solidifying workpiece remains, until the main extruder is filled with melt.

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[Add the following claims:]

28. (New) The process of claim 1 wherein the opening is formed in a nozzle of an extruder operatively connected to the injection mold.

REMARKS

This Amendment is submitted preliminary to the issuance of an Office Action in the present application.

Applicant has amended claims 1, 3 to 27 to present them in better form for examination. Claim 2 has been canceled. A check in the amount of \$184.00 to cover the surcharge for presenting eight claims in excess of twenty and five claims independent claims in excess of three is enclosed. In addition, applicant has amended the specification to present it with proper headings.

When the Examiner takes this application up for action, he is requested to take the foregoing into account.

The Commissioner is hereby authorized to charge fees which may be required, or credit any overpayment to Deposit Account No. 06-0502.

Respectfully submitted,

By:


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